

DART AEROSPACE LTD	Work Order:	22250
Description: Handle Assembly	Part Number:	D3331-041
Dwg: D3331 Rev. A	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.01.17	10
2	MFA MC	Cut handle to finish length as per Dwg D3331 Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall (M1025TR0.875W.125) Identify for D3331-1 Batch: <u>M16634</u>	EP	05/02/15	10
3	MFA MC	Form as per Dwg D3331 using DT8760 crimping Jig	CPL	05-02-15	10
4	MC	Turn as per Folio FA491 and Dwg D3331	EP	05/02/15	10
5	QC2	Inspect parts as they come off the CNC machine Identify as D3331-1	EP	05/02/15	10
6	QC8	Second check	EP	05-02-15	10
7	MC	Deburr	EP	05/02/15	10
8	MFA	Drill dowel hole as per Dwg D3331	CPL	05-02-16	10
9	MFA	Insert and Weld dowel as per Dwg D3331 Pick: Qty Part Number Description Batch 1 3/16"-1" long Dowel M16054 A/R N/A Steel Rod B9326	CPL	05-02-16	10
10	QC5	Inspect work to Step 9	ML	05 02 17	10
11	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	ML	05 02 17	10
12	QC3	Inspect Powder Coat	W	05-02-17	10
14	MFA	Assemble as per Dwg D3331 Pick: Qty Part Number Description Batch 1 GP-78R Black Vinyl Grid M16638 Identify as D3331-041	CPL	05-02-18	10
15	QC5	Inspect work to Step 14	EP	05.02.18	10
16	ST	Identify and Stock	CPL	05-02-18	10
17	AC	Cost / part: <u>25.29</u>	Syc	05.02.21	10
18	DC	Close W/O <u>25.29</u> Inspect Level 21	KJ	05.02.23	10

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

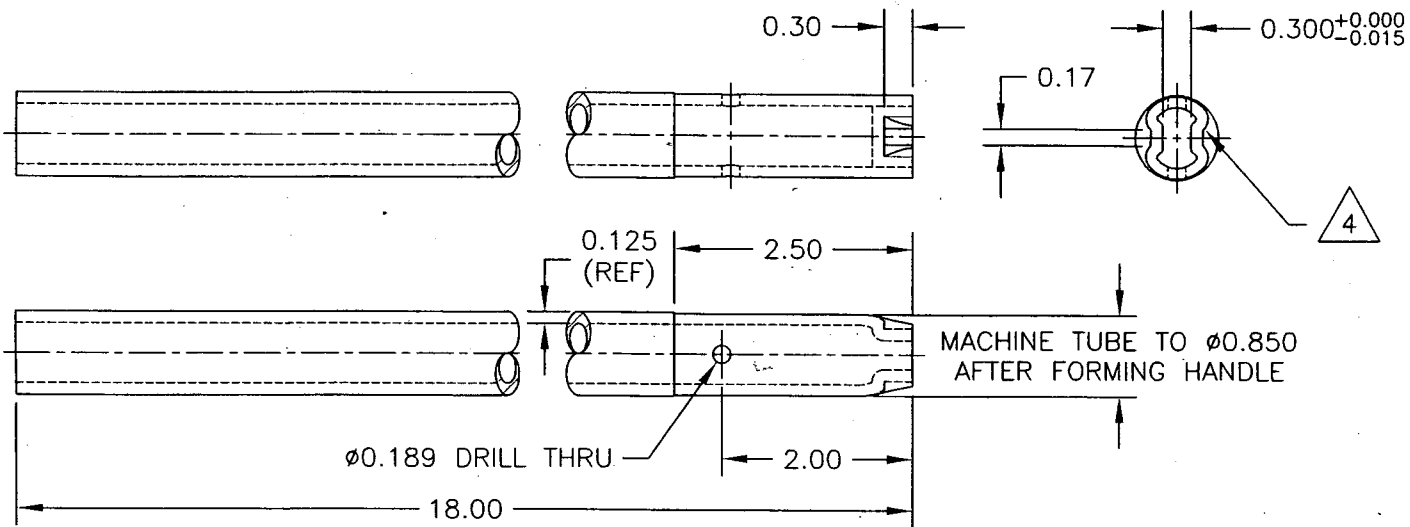
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

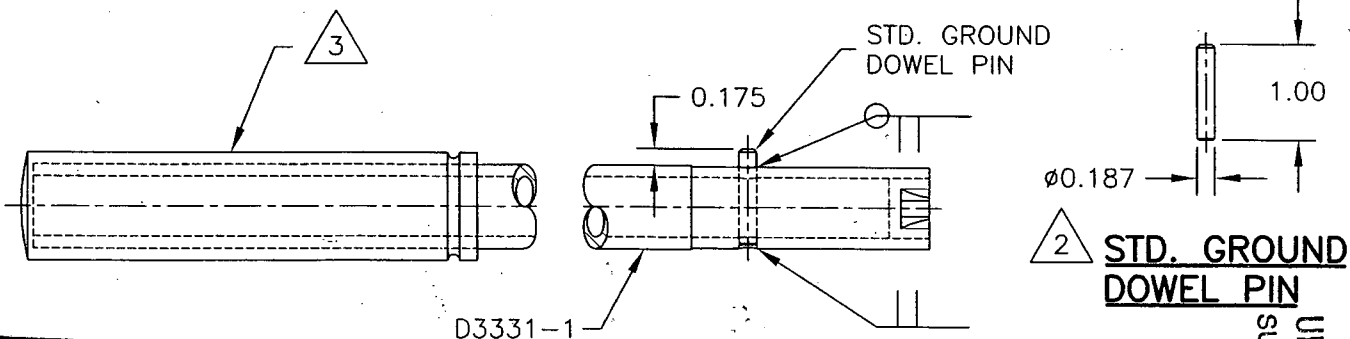
QA: N/C Closed: _____ Date: _____

DART

DESIGN BY <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3331	REV. A
DATE 04.11.29		TITLE HANDLE WELDMENT	SHEET 1 OF 1
A	04.11.29	NEW ISSUE	SCALE 1:2



D3331-1 HANDLE



D3331-041 HANDLE ASS'Y

NOTES:

- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR0.875W.125)
- 2) STD. GROUND DOWEL PIN, $\phi 3/16"$ x 1.00" LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-032
- 3) STD. BLACK VINYL GRIP, 7/8" I.D. x 4 3/4" LONG
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
- 4) FORM USING TOOLING DT8760
- 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22250

PRELIMINARY ISSUE

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
01:31 pm

Work Order No : 0022250
Project Name : D3331-041
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : D3331-041

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Description : Handle Assembly
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 01-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

